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Sub B2> METHOD FOR PRODUCING A BALL-AND-SOCKET JOINT BETWEEN
A SLIPPER AND A PISTON, AND A BALL-AND-SOCKET JOINT
5 OF THIS TYPE

ABSTRACT

10 The invention relates to a method for producing a ball-and-socket joint (1) between a
slipper (3) and a piston (2) of a piston engine, comprising the following steps:
configuring the slipper (3) with a joint ball (4) at the end opposite the bottom surface
(21); configuring the piston (2) with an overmeasure (x) on its lateral surface (2c) and
a hemispherical joint recess (5) with a recess edge (7) that protrudes beyond the
equator (6) of the joint recess (5), for the joint ball (4) at a front end of the piston (2);
15 bringing together the joint recess (5) and the joint ball (4); beading the recess edge (7)
into a form in which it grips the joint ball (4) from behind; and finishing the lateral
surface (2c) of the piston (2). The following steps are also provided for the purpose of
simplifying and improving the production process: bringing together the joint recess
(5) and the joint ball (4) after finishing the lateral surface (2c) of the piston (2); locally
20 heating the recess edge (7) to a temperature that reduces its hardness; and beading the
recess edge (7).

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